

# Work Order ID 71089

Wednesday, June 22, 2011 10:25:04 AM



Page 1

Item ID: D3021-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube Assembly

Start Date: 6/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/29/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-06-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3021	Rev A

100 Large Fab 0.00



Large Fab

Memo

0.00

Large Fab

1-Cut tube as per Dwg D3021

2-Drill tube as per Dwg D3021 using D8622

3-Deburr

4-Weld as per Dwg D3021 QSI004

A/R 4130 Rod Batch: M100075

Q 118-3 (X)

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

1 Q BE 11/08/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71089

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Item ID: D3021-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube Assembly

Start Date: 6/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/29/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:16 AM  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 10:45 AM

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 W/O 104

Ⓢ

1 117338 1 117338

IX 117338 117338

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 71089

Wednesday, June 22, 2011 10:25:04 AM



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Item ID: D3021-041	Accept		Setup	Start	
Revision ID:					
Item Name: Tube Assembly				Stop	
Start Date: 6/23/2011	Start Qty: 1.00				
Required Date: 6/29/2011	Req'd Qty: 1.00				
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Packaging Packaging	Identify as per dwg & Stock Location: <i>G-A</i>  Memo <i>70903</i>	0.00  0.00							<i>SP 11/08/10</i>
160  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<i>OK 11/08/10</i>

*11-08-10*  
*Q*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, June 22, 2011 10:24:59 AM

Page 1

Work Order ID: 71089

Parent Item: D3021-041

Parent Item Name: Tube Assembly

Start Date: 6/23/2011


Required Date: 6/29/2011

Start Qty: 1.00

Required Qty: 1.00


Comments: IPP 01.10.23 New Issue SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3017-11  cap		Manufactured	No			100	Each	15.0000	2	2			
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Location Loc Qty Loc Code

WA 15  
69074 15

M4130NT0.750W.049  4130 RD Tube .750 x.049W		Purchased	No			100	f	52.0000	2.0833	2.192947			
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Location Loc Qty Loc Code

MAT033 52  
117973 52

EL 11-6-23

2

EL 11-6-23

2.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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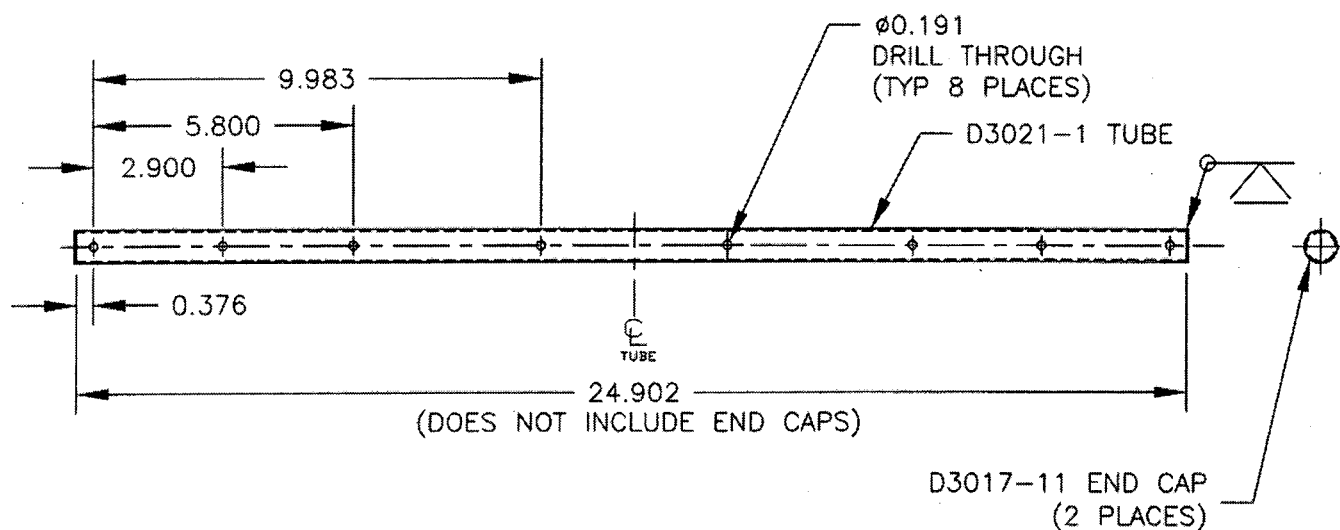
**NOTE:** Date & initial all entries





DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3021	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE TUBE ASSEMBLY	SCALE 1:4
A	01.05.18	NEW ISSUE	

# 71089



D3021-041 TUBE ASSEMBLY  
(D3021-1 TUBE)

NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) MATERIAL: AISI 4130 TUBE,  $\phi 0.75$  DIA x 0.049 WALL (M4130N-T0750W049)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

RELEASED  
01.05.30

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